



Dart Aerospace Ltd.
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D412-698-011
Job Sheet 183923



Part No: D412-698-011

Job Qty: 2 ea

Part Name: Cabin Door Roller LH Aluminum Door



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3
KJ/DS IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Ship Via:

5842

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Stores/Pkg-2	DAS 9-89	OCT 12 2018
110	Packaging	2 pcs	10/19/18	10/19/18	0.00	0.00	Packaging1-4	DAS 9-89	OCT 17 2018
120	QC	2 pcs	10/19/18	10/19/18	0.00	0.00	QC4	6 BB	OCT 17 2018
130	Packaging	2 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-2	9-89 BB	OCT 17 2018
135	DC	2 pcs	10/19/18	10/19/18	0.00	0.00	DC	21 9-89	OCT 17 2018
140	QC21-FG	2 Ea	10/19/18	10/19/18	0.00	0.00	QC21	9-89	OCT 17 2018

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP D412-698-011 Location;FG034

135 - Photocopy bluefile and create labels per PPP D412-698-011 CHG003

140 - QC21- Final Inspection - Work Order Release

DAS OCT 17 2018
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3121-141	Bracket Assembly	6 Ea (3 ea)	90-Start up Operation	5116696
D3121-143	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	51163724
D3137-043	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5117179
D3183-043	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5102311
D3199-1	Bracket	18 Ea (9 ea)	90-Start up Operation	5059065
D3202-1	Cover	2 Ea (1 ea)	90-Start up Operation	5023335

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3121-141	6	2	0
	D3121-143	2	10	0
	D3137-043	2	0	0
	D3183-043	2	4	0
	D3199-1	18	115	0
	D3202-1	2	20	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NC ☐ No ☐		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		ep #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Order Deviation		Disposition				Completed By	
Lead hand / Supervisor Approval Verification						QC / QA Coordinator Approval	
FAULT CATEGORY		Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
Env ☐ Design ☐ Operation ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		OTHER : _____					

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Container No: S117668



Part: D412-698-011

Job No: 183923

Serial No/Batch: S117668

Revision: G

Inspector: _____

Exp Date: _____

Instructions: TC STC SH92-43 Issue 5, FAI & STC SR014461

Specifications could not be found.

Plex 9/28/18 1:29 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

Change Record

PAGE 1 OF 1

Part Number: D412-698-011/-012

Description: CABIN DOOR ROLLER, LH/RH

[illegible]